

ABSTRACT OF INVENTION PATENT

“PROCESS FOR MANUFACTURE OF SANITARY WARE ACRYLIC PLATES, OF SYNTHETIC GRANITE, USING CAST SYSTEM, WITH OR WITHOUT ABS REINFORCEMENT”, presenting an inedited process for obtaining sanitary ware –

5 synthetic granite type acrylic, providing for the execution of two polymerization stages, the stage called first polymerization (D), is defined by a step called first mould preparation (D1); a step called mould filling (D2), where the mould is filled with the first formulation; a step called polymerization (D3) where the moulds are placed inside an autoclave, this operation obeying a thermal curve where the initial
10 temperature is 50°C, and after one hour this temperature is increased to 120°C and maintained constant until the end of the period with a total time of five hours, and after four hours begins the cooling step (D4) of the moulds and the plates polymerized inside it, passing to a mould cooling step (D4), plate demoulding step (D5); plate grinding step (D6) where the plates are grinded; a step called particle
15 selection (D7). The stage called second polymerization (E) presents a first step called second mould preparation (E1); a step called mould filling (E2); a step called degassing (E3); a step called polymerization (E4), where they are filled with the second formulation and placed inside the autoclave, whose thermal curve presents initial temperature of 50°C, increased to 80°C and maintained for one hour, after
20 this period the temperature is increased to a level of 120°C and maintained until the end of the period of four hours, after which begins the step of second cooling of the moulds (E5), where the moulds return to the autoclave, with a new and final polymerization; a step of final demoulding of the plates (E6).